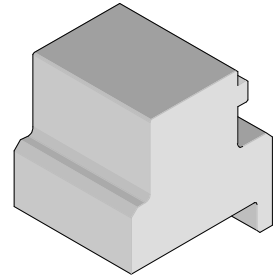




**I-Trac™ Power Module Installation
(Right Angle)
Application Tooling Specification
Press-In Tool
Order No. 62201-8629**



FEATURES

- Lip provided for positive alignment to connector assembly
- Tool provides uniform distribution of press force across entire pin array
- May be used as a stand-alone tool or mounted in an optional holder with other Molex press-in tools
- Fits in same rail as existing tools
- Can be placed on either side of existing power module with Daughtercard installed
- Use as stand-alone tool if power module is installed separately

SCOPE

Products: I-Trac™ Power Module Assembly, Right Angle 78239 Series, 15 Row Assemblies. See Product List below for specific part numbers.

Product List

The following is a partial list of the product order numbers and their specifications this tool is designed to run. Updates to this list are available on www.molex.com.

Right Angle Power Module Series No.	Row	Assembly Order Number							
78239	15	78239-1000	78239-1001	78239-1002	78239-1003	78239-1004	78239-1005	78239-1010	78239-1011
		78239-1012	78239-1013	78239-1014	78239-1015	78239-1020	78239-1021	78239-1022	78239-1023
		78239-1024	78239-1025	78239-1030	78239-1031	78239-1032	78239-1033	78239-1034	78239-1035
		78239-1040	78239-1041	78239-1042	78239-1043	78239-1044	78239-1045	78239-1050	78239-1051
		78239-1052	78239-1053	78239-1054	78239-1055				
		78239-1100	78239-1101	78239-1102	78239-1103	78239-1104	78239-1105	78239-1110	78239-1111
		78239-1112	78239-1113	78239-1114	78239-1115	78239-1120	78239-1121	78239-1122	78239-1123
		78239-1124	78239-1125	78239-1130	78239-1131	78239-1132	78239-1133	78239-1134	78239-1135
		78239-1140	78239-1141	78239-1142	78239-1143	78239-1144	78239-1145	78239-1150	78239-1151
		78239-1152	78239-1153	78239-1154	78239-1155				
		78239-1200	78239-1201	78239-1202	78239-1203	78239-1204	78239-1205	78239-1210	78239-1211
		78239-1212	78239-1213	78239-1214	78239-1215	78239-1220	78239-1221	78239-1222	78239-1223
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		78239-1312	78239-1313	78239-1314	78239-1315	78239-1320	78239-1321	78239-1322	78239-1323
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		78239-1340	78239-1341	78239-1342	78239-1343	78239-1344	78239-1345	78239-1350	78239-1351
		78239-1352	78239-1353	78239-1354	78239-1355				
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78239-1412	78239-1413	78239-1414	78239-1415	78239-1420	78239-1421	78239-1422	78239-1423		
78239-1424	78239-1425	78239-1430	78239-1431	78239-1432	78239-1433	78239-1434	78239-1435		

Press-In Tool for I-Trac™ Power Module Assembly

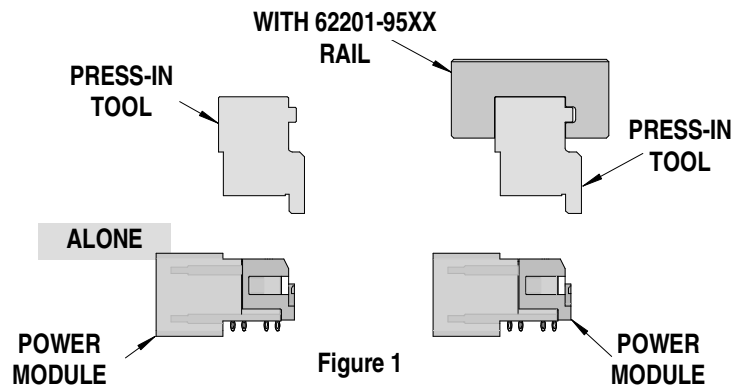
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		78239-1512	78239-1513	78239-1514	78239-1515	78239-1520	78239-1521	78239-1522	78239-1523
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		78239-1552	78239-1553	78239-1554	78239-1555				
		78239-2000	78239-2001	78239-2002	78239-2003	78239-2004	78239-2005	78239-2010	78239-2011
		78239-2012	78239-2013	78239-2014	78239-2015	78239-2020	78239-2021	78239-2022	78239-2023
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		78239-2052	78239-2053	78239-2054	78239-2055				
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		78239-2112	78239-2113	78239-2114	78239-2115	78239-2120	78239-2121	78239-2122	78239-2123
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		78239-2152	78239-2153	78239-2154	78239-2155				
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		78239-2240	78239-2241	78239-2242	78239-2243	78239-2244	78239-2245	78239-2250	78239-2251
		78239-2252	78239-2253	78239-2254	78239-2255				
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		78239-2352	78239-2353	78239-2354	78239-2355				
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		78239-2412	78239-2413	78239-2414	78239-2415	78239-2420	78239-2421	78239-2422	78239-2423
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		78239-2452	78239-2453	78239-2454	78239-2455				
		78239-2500	78239-2501	78239-2502	78239-2503	78239-2504	78239-2505	78239-2510	78239-2511
		78239-2512	78239-2513	78239-2514	78239-2515	78239-2520	78239-2521	78239-2522	78239-2523
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		78239-2552	78239-2553	78239-2554	78239-2555				
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		78239-5012	78239-5013	78239-5014	78239-5015	78239-5020	78239-5021	78239-5022	78239-5023
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		78239-5052	78239-5053	78239-5054	78239-5055				
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		78239-5112	78239-5113	78239-5114	78239-5115	78239-5120	78239-5121	78239-5122	78239-5123
		78239-5124	78239-5125	78239-5130	78239-5131	78239-5132	78239-5133	78239-5134	78239-5135
		78239-5140	78239-5141	78239-5142	78239-5143	78239-5144	78239-5145	78239-5150	78239-5151
		78239-5152	78239-5153	78239-5154	78239-5155				
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		78239-5212	78239-5213	78239-5214	78239-5215	78239-5220	78239-5221	78239-5222	78239-5223
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		78239-5240	78239-5241	78239-5242	78239-5243	78239-5244	78239-5245	78239-5250	78239-5251
		78239-5252	78239-5253	78239-5254	78239-5255				
		78239-5300	78239-5301	78239-5302	78239-5303	78239-5304	78239-5305	78239-5310	78239-5311

Press-In Tool for I-Trac™ Power Module Assembly

78239	15	78239-5312	78239-5313	78239-5314	78239-5315	78239-5320	78239-5321	78239-5322	78239-5323
		78239-5324	78239-5325	78239-5330	78239-5331	78239-5332	78239-5333	78239-5334	78239-5335
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		78239-5352	78239-5353	78239-5354	78239-5355				
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		78239-5412	78239-5413	78239-5414	78239-5415	78239-5420	78239-5421	78239-5422	78239-5423
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		78239-6052	78239-6053	78239-6054	78239-6055				
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78239-6324	78239-6325	78239-6330	78239-6331	78239-6332	78239-6333	78239-6334	78239-6335		
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78239-6352	78239-6353	78239-6354	78239-6355						
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78239-6552	78239-6553	78239-6554	78239-6555						

Tool Setup

Depending on the number of connectors to be installed and/or the press used, this tool can be used alone or with a group of press-in tools, mounted in a 62201-95XX rail (ordered separately). See Figure 1.



Tool Installation

The 62201-95XX rail is available in a variety of lengths to accommodate multiple press-in tools.

Rail Part Number	Rail Overall Length
62201-9501	24mm (0.94 in)
62201-9502	72mm (2.83 in)
62201-9503	156mm (6.14 in)
62201-9504	216mm (8.50 in)
62201-9509	254mm (10.0 in)
62201-9511	305mm (12.0 in)

Reference: The 62201-8629- Press-In Tool is 15.0mm (0.59 in.) long.

Printed Circuit Board (PCB) Support

The I-Trac™ connectors require up to 6.0kg (13.2 lb) of force per pin to press into the PCB. To prevent excessive PCB flexure and/or damage to the PCB, a support plate is strongly recommended directly beneath the connector terminal hole pattern.

Due to the custom nature of every application, a board support is required for proper tool application. This can be supplied by the customer or by Molex. For more information contact Molex Application Tooling.

When creating the PCB support plate, remember to allow clearance for the connector terminal pins as they pass through the PCB thickness.

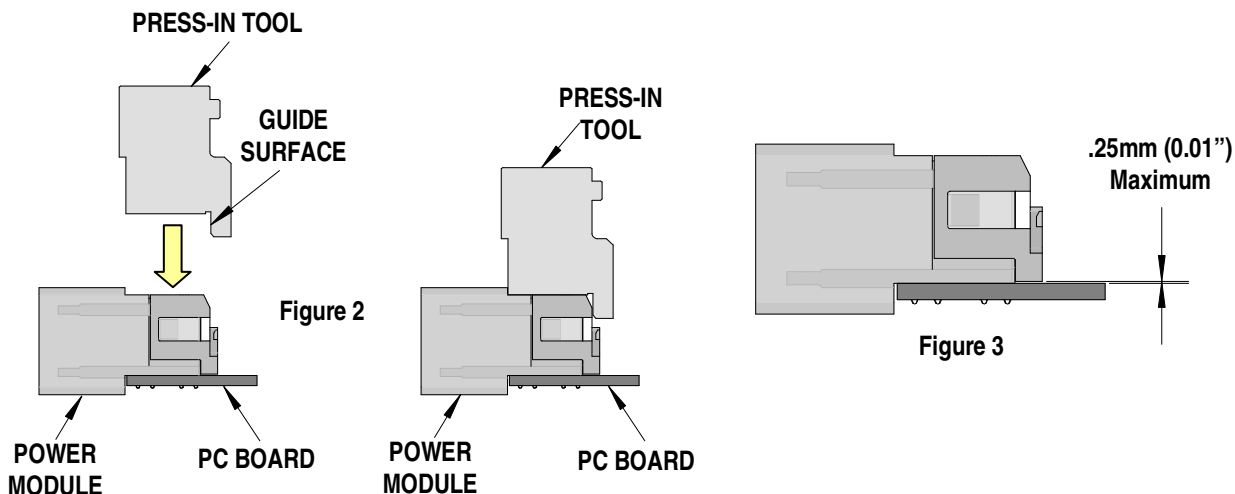
Press Equipment Recommendations

Many types of presses can be used to install I-Trac™ connectors, but to assure consistent connector installation Molex recommends the following press criteria:

1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press stroke must be at least 19mm (0.75 in).
5. For statistical purposes, automatic collection of force and distance data.

Tool Operation

1. Carefully insert, by hand, the power module(s) into the PCB hole pattern.
2. Place the application tool on top of the power module with the back guide surface of the tool against the back of the power module. See Figure 2.



3. Using the application tool and an appropriate press, seat the power module until there is less than 0.25mm (0.01 in) clearance between the bottom of the plastic housing and the surface of the PCB. See Figure 3.

CAUTION: To prevent injury, never operate any press without the guards in place. Refer to the press manufacturer's instruction manual.

CAUTION: Molex application tooling specifications are valid only when used with Molex connectors and tooling.

Contact Information

For more information on Molex application tooling please contact Molex at 1-800-786-6539.

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